

Date: Thursday, 6/29/2006 3:52:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS
 Job Number : 27799
 Estimate Number : 10578
 P.O. Number : N/A Part Number : D34533
 This Issue : 6/29/2006 S.O. No. : N/A Drawing Number : D3453 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27702 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 7/12/2006 Qty: 6 Um: Each
 Checked & Approved By : 06/06/29
 Comment : A 05.09.27 New issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1250 Inventory



Comment: Qty.: 0.2452 f(s)/Unit Total: 1.4712 f(s)

Material: AISI 304 SS Round Bar Ø1.250

(M304R1.250)

Batch: M190527

M101549

06/07/11

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA578 Rev: _____ & Dwg D3453 Rev: N/A Machined Manually

2- Deburr as per dwg D3453

06/07/12

6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/12

6

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA578 Rev: _____ & Dwg D3453 Rev: N/A Machined Manually

2- Deburr as per dwg 3453

06/07/13

6

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/13

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LS Date: 26/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 3:52:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27799

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

[Signature]

06/07/13 x 6

PTO

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature]

06/07/13 x 6

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/07/13 x 6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5438*

06/27/15 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion





u 06.07.15

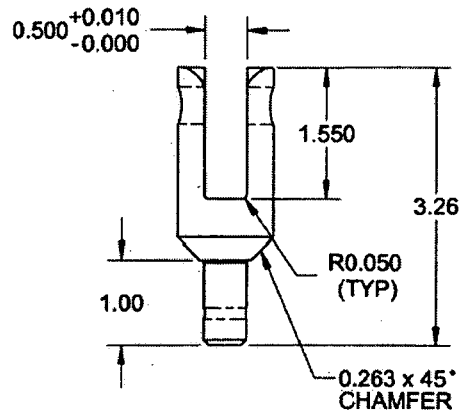
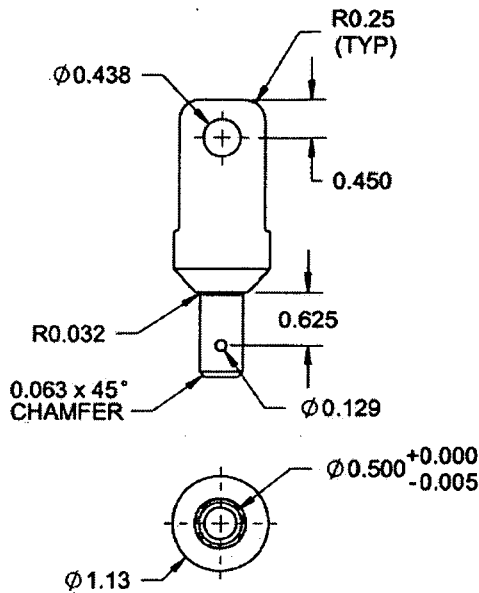
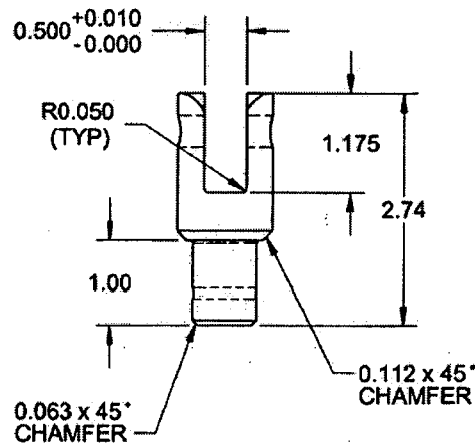
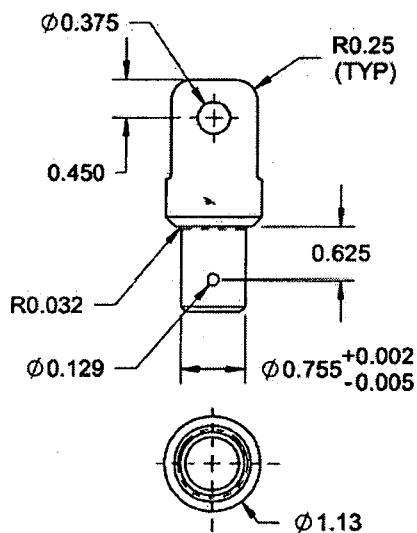

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27799		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-13	6.	hole was located at the wrong location with the center drill at first. only .030 deep & .100 wide. when the good hole was drilled, the center drill mark was still visible on the edge of the hole. Very tiny	AB GSE J	fill void with weld, and grind flush & re-drill hole as necessary.	PD 06-07-13 66/07/13	06-07-13	06/07/13	06-07-13

Part No: D3453-3 PAR #: N/A Fault Category: Prod - CNC NCR: Yes No DQA: LS Date: 06-07-17
 NOTE: Date & initial all entries QA: N/C Closed: JA Date: 06-07-17

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

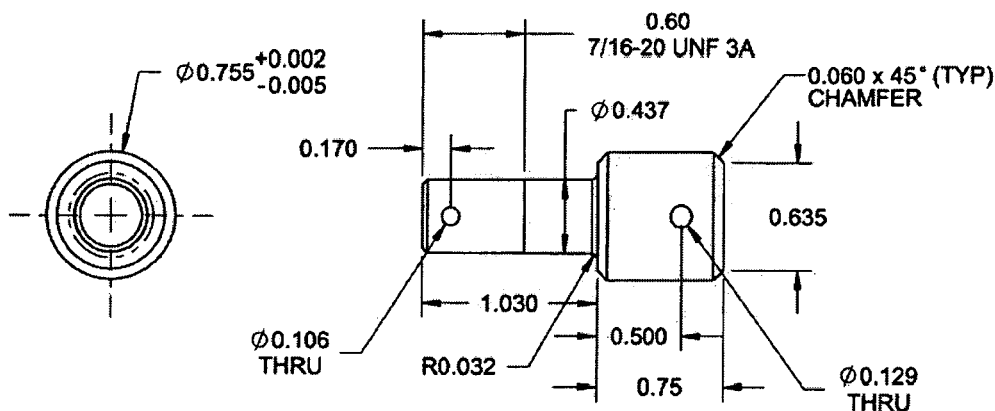
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:1

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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